

Date: Monday, 2/27/2006 4:08:05 PM
 User: Kim Johnston

Process Sheet

Never pulled
 not set
 removed from A1026
 07/01/17

| | | | | | |
|-----------------------|--|--|------------------|-----------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : STEP WELDMENT | |
| Job Number | : 25943A | | Part Number | : D2563 | |
| Estimate Number | : 10176 | | Drawing Number | : D2563 REV C | |
| P.O. Number | : N/A | | Project Number | : N/A | |
| This Issue | : 2/27/2006 S.O. No. : N/A | | Drawing Revision | : C | |
| Prsht Rev. | : NC | | Material | : N/A | |
| First Issue | : N/A | | Due Date | : 3/17/2006 | |
| Previous Run | : 25558A | | Qty: | 10 Um: Each | |
| Written By | : See COMMENT Below | | | | |
| Checked & Approved By | : D. 06.02.28 | | | | |
| Comment | : Est Rev:G 02.07.01 Re-format Location RF | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|--|---|
| 1.0 | D2244116 | Step Extrusion | |
| | | | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) | |
| | | Pick: | |
| | 1 | D2244 Step Extrusion | |
| | | Batch: 20457 | <i>LE. 06.03.29</i> |
| 2.0 | D267334 | End Plate | |
| | | | |
| | | Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s) | |
| | | Pick: | |
| | Qty | Part No. | Description |
| | 2 | D2673-34 | End Cap |
| | | | <i>325.386</i> |
| 3.0 | D2561 | Lug Plate | |
| | | | |
| | | Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s) | |
| | | Pick: | |
| | Qty | Part No. | Description |
| | 2 | D2561 | Lug Plate |
| | | | <i>325.088 = 9 B25948 = 11 LE. 06.03.29</i> |
| 4.0 | D2564 | Mounting Angle | |
| | | | |
| | | Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s) | |
| | | Pick: | |
| | Qty | Part No. | Description |
| | 2 | D2564 | Mounting Angle |
| | | | <i>324496 LE. 06.03.29</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
QA: N/C Closed: _____ Date: _____

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:08:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 25943A

Part Number: D2563

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563

SE. 06.03.30

10

2-Deburr ends

SE. 06.04.3

10

3-Weld (1 End Only) as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M18838

SE. 06.04.4

10

4-Grind

FF 06.04.05

10

6.0 QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-04-05

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAO 06:04:08

10

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MM 06 04 10

(10)

9.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

SE. 06.04.12

10

2-Weld Remainig End as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M18838

SE. 06.04.12

10

3-Grind

FF 06.04.17

00

10.0 QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:08:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 25943A

Part Number: D2563

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Touch up Alodine then *a.m 06-04-18*

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-04-18

(10)

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

FC 06 04 19 (10)

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1/4/10 (10)

14.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

1/6/10 (10)

Job Completion



6-04-10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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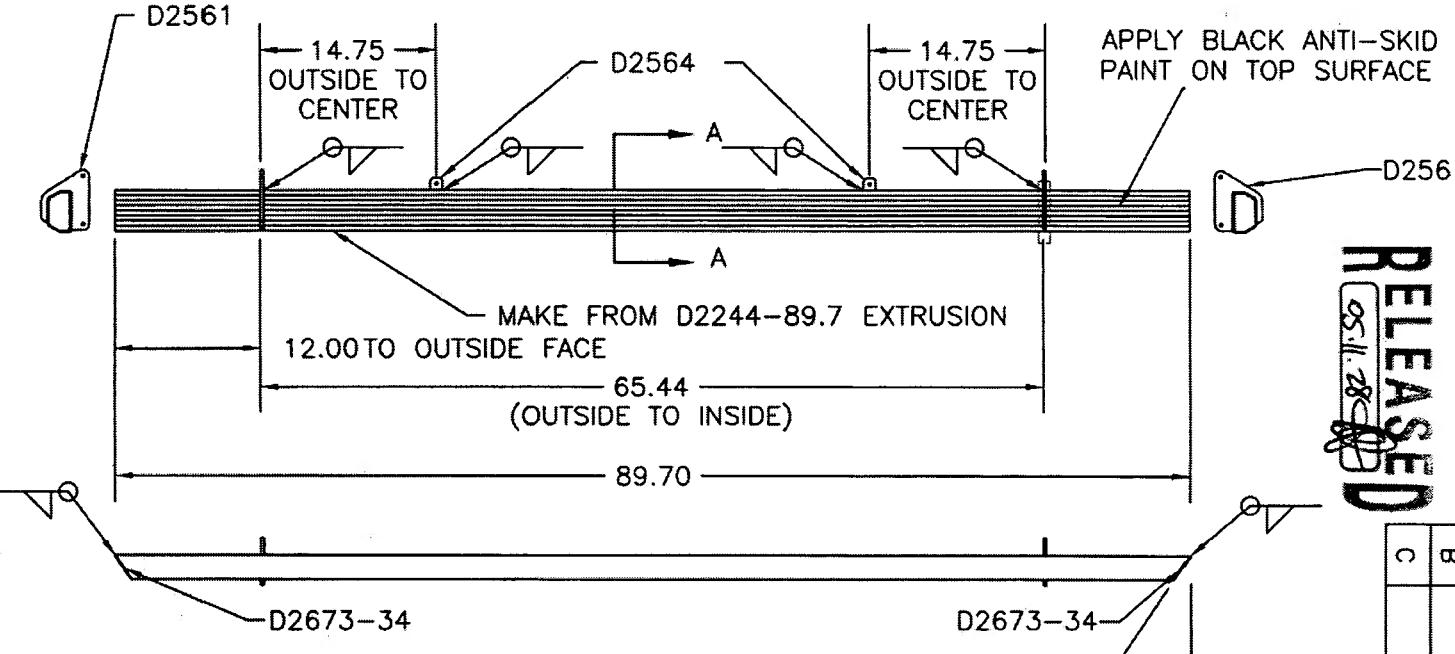
NOTE: Date & initial all entries

DART

DESIGN
BW *44* DRAWN BY **DART AEROSPACE LTD**
CHECKED *MM* APPROVED *MM* DRAWING NO. **HAWKESBURY, ONTARIO, CANADA**
DATE **05.11.14** TITLE **D2563** REV. C
TITLE **STEP WELDMENT ASSEMBLY** SHEET 1 OF 1
SCALE **1:15**

RELEASED
05.11.28.00

| | | |
|----------|-----------------|-------------------------------------|
| A | 96.04.26 | NEW ISSUE |
| B | 97.05.14 | END CAPS CHANGED (WAS D2248) |
| C | 05.11.14 | UPDATE NOTES |

**D2563 STEP WELDMENT ASSEMBLY PARTS LIST**

| Part No. | Description | QTY |
|--------------|-------------------------------|----------|
| D2563 | STEP WELDMENT ASSEMBLY | X |
| D2244-89.7 | EXTRUSION* | 1 |
| D2561 | LUG PLATE | 2 |
| D2564 | MOUNTING ANGLE | 2 |

*cut per drawing

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. *25143*

SHOP COPY
RETURN TO
ENGINEERING

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Date: Monday, 2/27/2006 4:07:57 PM
 User: Kim Johnston

Process Sheet

| | | | | | | |
|-----------------------|---|--|--------------|-----------------------------|--------------|----------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : 205 STEP(STANDARD HEIGHT) | | |
| Job Number | : 25943 | | | | | |
| Estimate Number | : 10180 | | | | | |
| P.O. Number | : | | | Part Number | : D205633011 | |
| This Issue | : 2/27/2006 | | S.O. No. : | Drawing Number | : N/A | |
| Prsht Rev. | : NC | | | Project Number | : N/A | |
| First Issue | : / / | | Type : | Drawing Revision | : N/A | |
| Previous Run | : 24478 | | | Material | : | |
| Written By | : | | | Due Date | : 3/17/2006 | |
| Checked & Approved By | : <u>DK</u> 06.02.28 | | | Qty: | 10 | Um: Each |
| Comment | : Est Rev:F 02.07.11 Reformat; Removed D3010 RF | | | | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------|---------------|
| 1.0 | 25943A | STEP WELDMENT |
|-----|--------|---------------|



| |
|--------------------------------------|
| Comment: Sub-Component STEP WELDMENT |
|--------------------------------------|

| | | |
|-----|----|------------------|
| 2.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



| |
|---------------------------|
| Comment: DOCUMENT CONTROL |
|---------------------------|

| |
|--|
| Photocopy bluefile & type labels per PPP205-633-011 CHG001 |
|--|

DK 06-02-28

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



| |
|--------------------------------|
| Comment: PACKAGING RESOURCE #1 |
|--------------------------------|

| |
|------------------|
| Pick Packing Kit |
|------------------|

| | | |
|-----|----------|---------|
| 4.0 | D2021101 | Eyebolt |
|-----|----------|---------|



| |
|--|
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) |
|--|

| |
|-------------------|
| Pick: Packing Kit |
|-------------------|

| |
|-----------------------------------|
| Qty Part Number Description Batch |
|-----------------------------------|

| |
|-----------------------------------|
| 1 D2021-101 Eyebolt <u>B23yf3</u> |
|-----------------------------------|

| | | |
|-----|----------|--------|
| 5.0 | D2022101 | Spacer |
|-----|----------|--------|



| |
|--|
| Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s) |
|--|

| |
|-------------------|
| Pick: Packing Kit |
|-------------------|

| |
|-----------------------------------|
| Qty Part Number Description Batch |
|-----------------------------------|

| |
|----------------------------------|
| 2 D2022-101 Spacer <u>B23396</u> |
|----------------------------------|

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 25943

Part Number: D205633011

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D2022103 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2022-103 Spacer B24271 1mc4 B25047 6mc4

7.0 D2562001 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2562-001 Strut B24392 4mc4 B24272 6mc4

8.0 D2565101 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-101 Strut B26392 4mc4 B24273 5mc4 B25971 1mc4

9.0 D2565103 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-103 Strut B26392 4mc4 B25972 6mc4

10.0 D2565105 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-105 Strut B23184 1mc4 B26392 4mc4 B25973 6mc4

11.0 D2565107 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-107 Strut B26392 4mc4 B25974 6mc4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 25943

Part Number: D205633011

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 D2565109 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-109 Strut B24277 1mcg B25975 6mcg

13.0 D2565111 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-111 Strut B24278 1mcg B26392 4mcg

14.0 AN45A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-5A Bolt M100 089 ✓

15.0 AN46A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-6A Bolt M19278 ✓

16.0 AN47A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-7A Bolt M18369 ✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:07:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 25943

Part Number: D205633011

Job Number:



Seq. #: Machine Or Operation:

Description :

17.0 AN414A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4-14A Bolt M15072 /

18.0 AN56A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN5-6A Bolt M18576 /

19.0 AN514A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN5-14A Bolt M17568 /

20.0 AN960JD416 Washer



Comment: Qty.: 15.0000 Each(s)/Unit Total : 150.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

15 AN960JD416 Washer M100575 /

21.0 AN960JD516 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M19185 /

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:07:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 25943

Part Number: D205633011

Job Number:



Seq. #: Machine Or Operation:

Description :

22.0 MS21042L4 Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 MS21042L4 Nut M19099

23.0 MS21042L5 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
2 MS21042L5 Nut M19073

24.0 D2563 Step Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
1 D2563 Step Weldment 325943 A

25.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SB 04/04/19

26.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-011

Location: Rev. G

SB 06/04/20 10

27.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/04/21 10

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | 26519 72 643 | | | | | |
| | | 24988 013 | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/04/07
 QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries